

Work Order ID 72987

Tuesday, August 23, 2011 8:30:49 AM



Page 1

Item ID: D3912-041

Accept



Setup Start



Revision ID:

Item Name: Eyebolt Receiver Assembly

Stop



Start Date: 8/23/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 8/29/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-08-23

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3912

B

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

SP 1169102

110

0.00



Small Fab

Memo

0.00

Small Fab

1-Assemble D3912-1/-3/-5 and install rivets as per dwg
TRIM RIVETS 1.250" LONG

2- Install helical spring plunger and spring pin lanyard assy as per dwg

SP 1169102 (3)

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

SP 1169102

(73)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: *SH*

0.00



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*08/24/11 ③**11/9/11**UMF
11-09-02*

W/O:		WORK ORDER CHANGES					
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Picklist Print

Tuesday, August 23, 2011 8:30:55 AM

Page 1

Work Order ID: 72987

Parent Item: D3912-041

Parent Item Name: Eyebolt Receiver Assembly






Start Date: 8/23/2011

Required Date: 8/29/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: new issue DD 09.11.18 verified by:EC IPP Rev:B
10.06.10 memo in seq110 ***IF PLUNGER GOES IN TO DEEP, INSTALL A
WASHER (AN960C516L) IF NECESSARY BETWEEN PLUNGER AND
D3912-1. YOU MAY HAVE TO ENLARGE WASHER HOLE FOR IT TO
FIT*** DD verf:JLM IPP REV:C AS PER REV B 10-08-05 JLM
VERIFIED:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status															
NAS1149C0663R  Washer		Purchased	No				Each	232.0000		4																		
<table><tr><th><u>Location</u></th><th><u>Loc Qty</u></th><th><u>Loc Code</u></th></tr><tr><td>ST297</td><td>232</td><td></td></tr><tr><td>110139</td><td>32</td><td></td></tr><tr><td>116893</td><td>200</td><td></td></tr></table>														<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	ST297	232		110139	32		116893	200				
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ST297	232																											
110139	32																											
116893	200																											
D3912-1  Eyebolt		Manufactured	No			100	Each	22.0000	1	4																		
<table><tr><th><u>Location</u></th><th><u>Loc Qty</u></th><th><u>Loc Code</u></th></tr><tr><td>FG091</td><td>22</td><td></td></tr><tr><td>69593</td><td>20</td><td></td></tr><tr><td>69606</td><td>2</td><td></td></tr></table>														<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	FG091	22		69593	20		69606	2				
<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>																										
FG091	22																											
69593	20																											
69606	2																											
D3912-3  Eyebolt Block		Manufactured	No			100	Each	29.0000	2	8																		
<table><tr><th><u>Location</u></th><th><u>Loc Qty</u></th><th><u>Loc Code</u></th></tr><tr><td>ST090</td><td>4</td><td></td></tr><tr><td>69539</td><td>4</td><td></td></tr><tr><td>ST091</td><td>25</td><td></td></tr><tr><td>70424</td><td>25</td><td></td></tr></table>														<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	ST090	4		69539	4		ST091	25		70424	25	
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ST090	4																											
69539	4																											
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70424	25																											

SB 11/09/12

SB 11/09/12

SB 11/09/12

W/O:		WORK ORDER CHANGES					
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Work Order ID: 72987

Parent Item: D3912-041

Parent Item Name: Eyebolt Receiver Assembly

Start Date: 8/23/2011

Required Date: 8/29/2011

Start Qty: 4.00

Required Qty: 4.00

D3912-5 Manufactured No

100 Each 0.0000

8



Eyebolt Plate

B 72984



SB 11/69/02

D3801-1 Manufactured No

Each 14.0000

4



Hand Retractable Spring Plunger



SB 11/69/02

Location

Loc Qty

Loc Code

ST083

12

69498

12

ST084

2

68379

2

3

MS20615-4M20 Purchased No

100 Each 216.0000

8

32



RIVET



SB 11/69/02

Location

Loc Qty

Loc Code

GA

216

117071

46

118571

170

24

MS21209-F615 Purchased No

Each 37.0000

4



Heli-Coil



SB 11/69/02

Location

Loc Qty

Loc Code

ST305

37

108170

23

108244

14

3

Tuesday, August 23, 2011 8:30:55 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

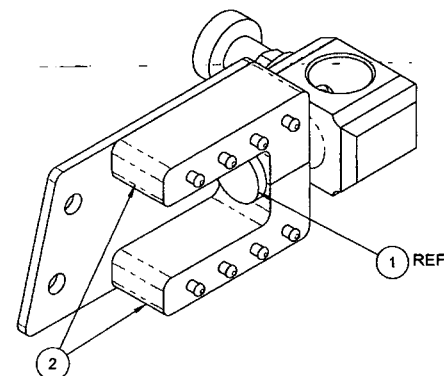
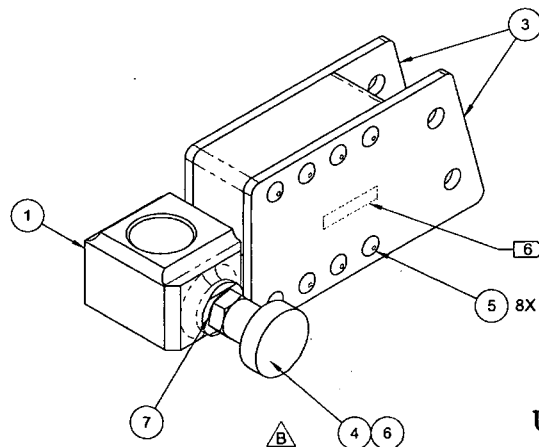
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3912-041	EYEBOLT RECEIVER ASSY
1	1	D3912-1	EYEBOLT
2	2	D3912-3	EYEBOLT BLOCK
3	2	D3912-5	EYEBOLT PLATE
4	1	D3801-1	SPRING PLUNGER
5	8	MS20615-4M20	RIVET
6	1	MS21209-F615	HELICAL
7	1	NAS1149F0332P	WASHER



SUPPLEMENTAL ISO VIEW
(EYEBOLT PLATE REMOVED
TO SHOW INTERIOR FEATURES)

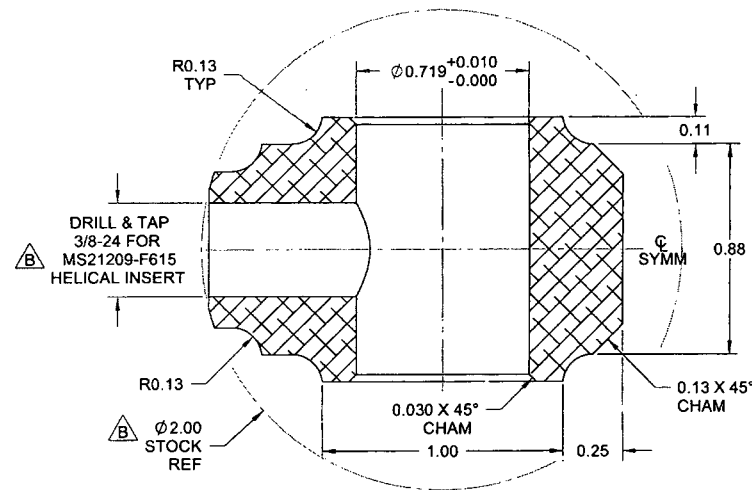
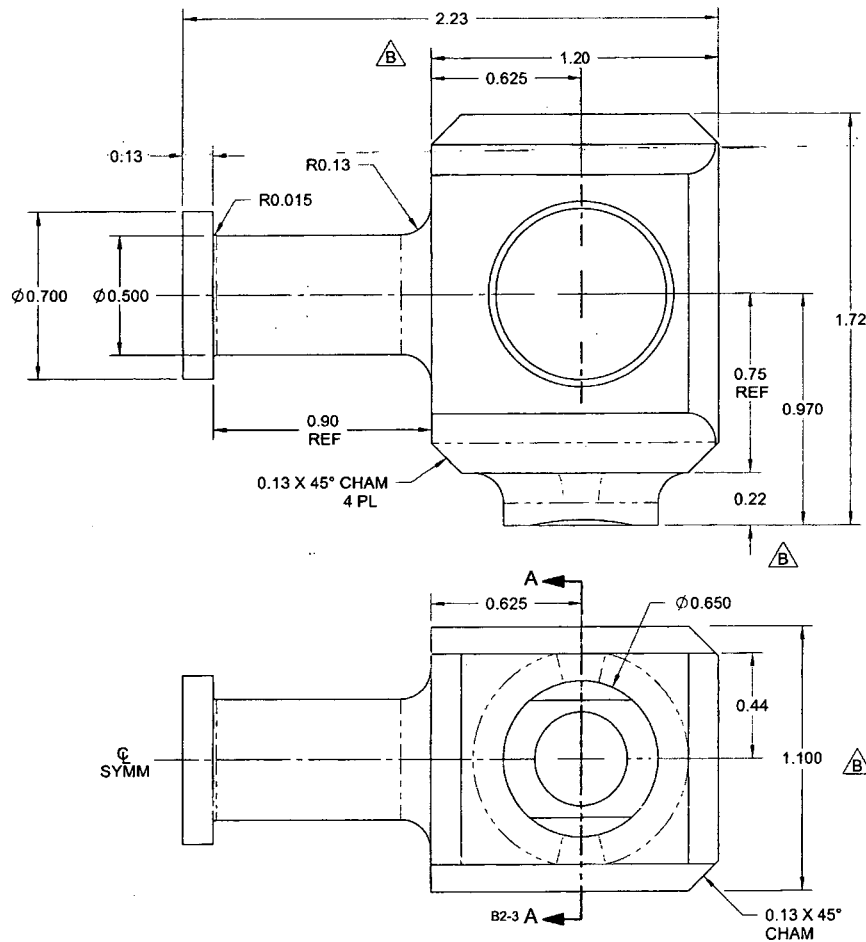
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72287

11-08-23

D3912-041 EYEBOLT RECEIVER ASSY

- NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING
FINE POINT PERMANENT INK MARKER
7) WEIGHT -041: 1.58 lbs

B	D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMV; MS21209-F615 WAS MS21209-C610 HELICAL; (1) WASHER NAS1149C0863R ADDED; BOSS ADDED TO D3912-1.	JPH	10.06.28
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>ALS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>JS</i>	DRAWING NO.	REV. B
CHECKED	<i>JS</i>	D3912	SHEET 1 OF 3
MFG. APPR.	<i>JS</i>	TITLE	SCALE
APPROVED	<i>JS</i>	EYEBOLT RECEIVER ASSY	NTS
DE APPR.	<i>JS</i>	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.06.28		



SECTION A-A B6-3

RELEASED
2010-07-16

D3912-1 EYEBOLT

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
REF DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 013 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT: 0.45 lbs

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	11	HAWKESBURY, ONTARIO, CANADA	
CHECKED	11	DRAWING NO.	REV. B
MFG. APPR.	11	D3912	SHEET 2 OF 3
APPROVED	11	TITLE	SCALE
DE APPR.	11	EYEBOLT RECEIVER ASSY	NTS
DATE	10.06.28	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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2010-07-16

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DRAWN	<i>ALS</i>		SHEET 3 OF 3
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MFG. APPR.	<i>ALS</i>		NTS
APPROVED	<i>ALS</i>		
DE APPR.	<i>ALS</i>		
DATE	10.06.28		